

b11
c1
weld

a) forming broad faces of the strand shell to have planar surfaces in a region of the immersion nozzle, and simultaneously be parallel with respect to their contour lines;

b) outside a region of the immersion nozzle, shaping said broad faces of the strand shell with planar surfaces that taper conically toward the narrow faces;

c) in a strand casting direction, feeding parts of the slab broad faces shaped with planar surfaces conically to each other up to 40 to 60% of the mold length to such a degree that lateral edges of the faces adapt themselves to ends of the planar parts of the slab broad faces tapering conically with respect to narrow faces of the slab;

d) joining tapered connecting pieces with the central parts of the slab broad faces with respective planar-surface edge parts of the slab broad faces; and

e) subsequently, in a mouth region and after leaving the mold, maintaining convexity formed by in each case three planar surface parts of the broad faces of the strand shell constant in its form as far as a lowest point of a liquid crater of the slab.

12. A process as defined in claim 11, including reducing slab thickness in a region of a strand guiding framework by only deforming the narrow faces of the slab.

13. A process as defined in claim 11, wherein the tapered connecting pieces between the central part of the slab, located in the region of the immersion nozzle, and the slab broad-face parts tapering conically toward the narrow faces are given a form which encloses an angle $\alpha < 5^\circ$ in a longitudinal direction of the central parts of the slab and represents a crowned

surface which, having a central point of inflection, adjoins tangentially at its edges to two neighboring surfaces.

14. A continuous casting installation for producing a thin slab, comprising:

SB
C2
a laterally adjustable mold, the mold having broad side parts, narrow side parts, a large crowned cross-section on a charging side and a cross-section, opposite the crowned cross-section, on a strand outlet side which is smaller than the crowned cross-section and identically crowned in a central region;

an immersion nozzle that protrudes into the mold, the immersion nozzle having a mouth with a maximum thickness (d) corresponding to $d = 0.3$ to $0.5 \times D_E$, where D_E is a distance between the mold broad face parts in a charging region, the broad-side parts having at least in a region of the immersion nozzle central parts which are arranged parallel to one another according to their contour lines, the broad-side parts being formed, at least in an adjusting region of the narrow-side parts, as planar side surfaces, the planar side surfaces being movably arranged so that they move conically toward each other in a direction of the narrow-side parts, the central part being connected to the planar-surface side surfaces by transitional parts, the transitional parts tapering toward each other and having a tip that ends at a distance (a), measured from an upper edge of the mold, with $a = 0.5$ to $0.8 \times L$, where L = the length of the mold; and

pairs of supporting and guiding rollers which follow the mold and have a caliber adapted to an emerging crowned strand, the supporting and guiding rollers having a contour which corresponds to the central part and the side parts of the mold broad faces in a region of a mouth of the mold.

16. A continuous casting installation as defined in claim 14, wherein the central parts are shaped with planar surfaces in the region of the immersion nozzle up to $a = 0.5$ to $0.8 \times L$ and are arranged so as to be disposed parallel to one another, the mold further having connecting parts with contour lines, the connecting parts being parallel with respect to their contour lines and having in a strand conveying direction an S-shaped form with ends that respectively go over tangentially into a preceding and following part of the central part, the transitional parts being adapted to the connecting part in their longitudinal extent up to the tip.

18. A continuous casting installation as defined in claim 14, wherein the supporting and guiding rollers are split rollers having bearings provided in a region of the central part.

IN THE ABSTRACT OF THE DISCLOSURE:

Please cancel the current Abstract of the Disclosure and insert therefor the abstract attached hereto on a separate sheet.